

Work Order ID 155673

155673

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Wednesday, January 18, 2017 7:16:18 AM

Item ID: D4148-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Lug Plate, Fwd
 Start Date: 2/6/2017 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 2/8/2017 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: MUF Date: 17-1-20 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4148	E							DAS 46 9-89	17/02/04
100		0.00							
100									
Waterjet	Memo	0.27							
FLOW CNC Waterjet	Cut as per dwg D4148								
	Prog Rev: <u>E</u>								
	Dwg Rev: <u>E</u>								
	OPEN HOLES TO SIZE AS PER DWG								
	Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.02							
Quality Control									

10

10 DAS 46 9-89 17/02/22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Work Order ID 155673***155673***

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.03				<u>10</u>			DAS 38 9-89 MAR 01 2017
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>Sto85</u> Memo	0.00 0.02				<u>10</u>			DAS 6 9-89 MAR 01 2017
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.17							DAS 21 9-89 MAR 02 2017
									DAS 21 9-89 MAR 02 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

Tuesday, January 17, 2017 1:13:25 PM

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Work Order ID: 155673

155673

Parent Item: D4148-1

D4148-1

Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 2/6/2017

Required Date: 2/8/2017

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.10.29 as per revC DD verf:EC

11.03.02 AS PER DWG REV.D DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

40.4100

0.3607

3.796842

DAS

46

9-89

17/02/04

M304S11GA

304/316 0.125 Sheet

**

Location

Loc Qty

Loc Code

MAT020

40.40998

M129545

0.00109

M134604

2.5

M135355

5.90889

M136327

32

3.6

DQA: _____ Date: _____



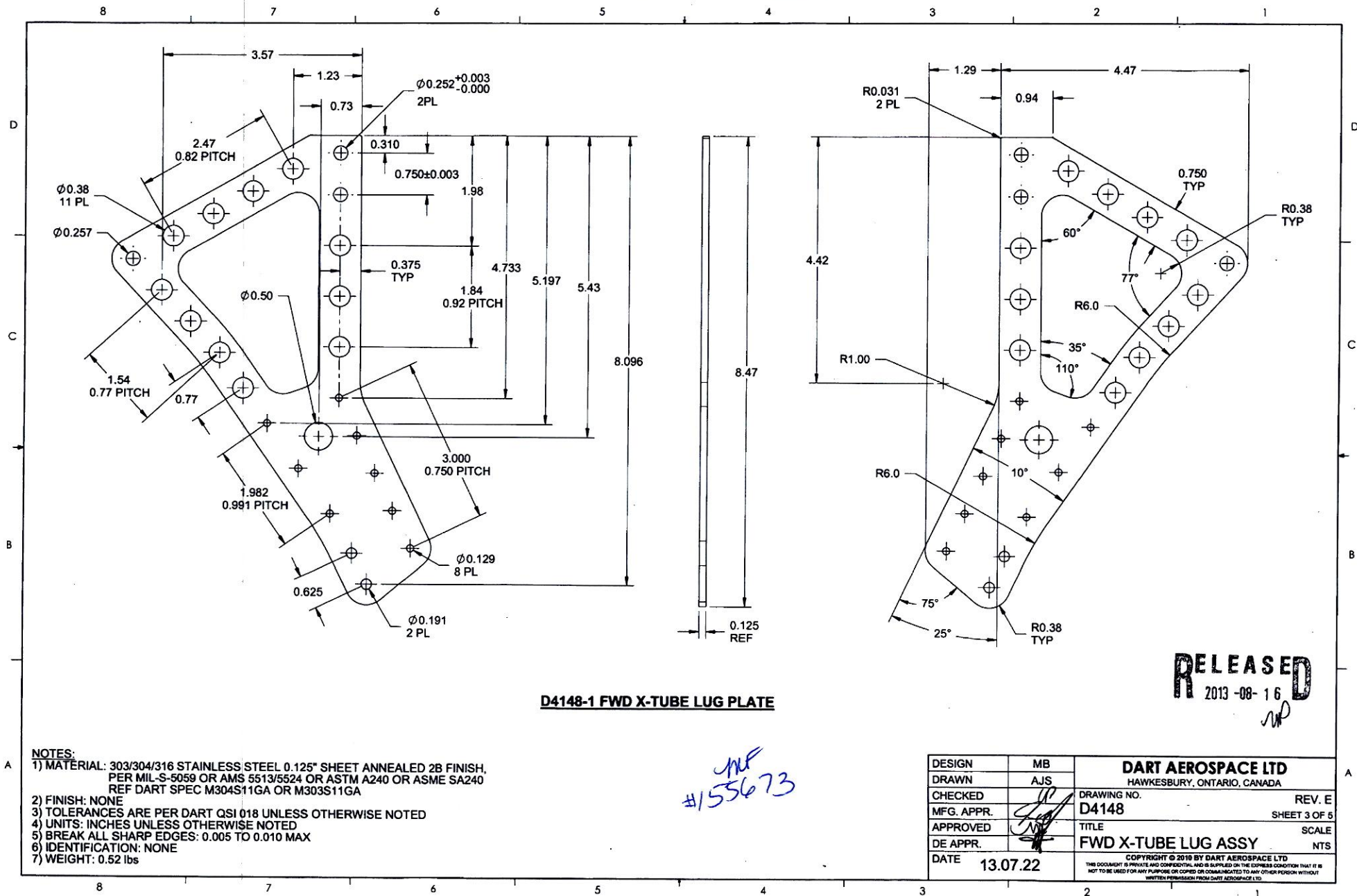
WORK ORDER NON-CONFORMANCE / UPDATE

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
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Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
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Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
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Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
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Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

DART AEROSPACE LTD		Work Order: 155673
Description: Fwd Crosstube Lug Plate		Part Number: D4148-1
Inspection Dwg: D4148	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	✓		DC-01	
Ø0.191	+0.005/-0.001	0.192	✓			
Ø0.38	+0.006/-0.001	0.380	✓			
Ø0.257	+0.006/-0.001	0.258	✓			
Ø0.50	+0.008/-0.001	0.504	✓			
0.94	+/-0.030	0.94	✓			
4.47	+/-0.030	4.471	✓			
0.750	+/-0.010	0.752	✓			
8.47	+/-0.030	8.475	✓			
8.096	+/-0.010	8.096	✓			
5.43	+/-0.030	5.453	✓			
5.197	+/-0.010	5.197	✓			
4.733	+/-0.010	4.740	✓			
0.310	+/-0.010	0.312	✓			
0.750	+/-0.010	0.751	✓			
0.375	+/-0.010	0.381	✓			
1.84	+/-0.030	1.834	✓			
0.92	+/-0.030	0.916	✓			
3.000	+/-0.010	3.007	✓			
0.750	+/-0.010	0.751	✓			
0.625	+/-0.010	0.633	✓			
1.982	+/-0.010	1.988	✓			
0.991	+/-0.010	0.993	✓			
0.77	+/-0.030	0.772	✓			
1.54	+/-0.030	1.536	✓			
2.47	+/-0.030	2.467	✓			
0.82	+/-0.030	0.825	✓			
3.57	+/-0.030	3.57	✓			
1.23	+/-0.030	1.234	✓			
0.73	+/-0.030	0.748	✓			
0.125	+/-0.010	0.117	✓			
Ø0.252	+0.008/-0.000	0.253	✓			

Measured by: 46 9-89	Audited by: 38 9-89	Preliminary Approval:
Date: 17/02/201	Date: 17-03-01	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.10.08	Dwg Rev updated	KJ	
C	10.11.05	Dimensions updated per Dwg Rev C	KJ	
D	11.03.08	Dwg Rev updated	KJ	
E	12.02.01	Dimensions updated per Dwg Rev D	KJ	
F	13.11.26	Dwg Rev updated	KJ	

DQA: _____ Date: _____



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